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D4018-041
Job Sheet 188226



Part No: D4018-041

Job Qty: 1 pcs

Part Name: AS350 Short Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 2/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A, D4018 REV E SHEETS 1,2,3 IPP RevA: new issue DD 09.11.30 verified by:EC IPP
Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	Large Fab - Basket - 1	1 pcs	2/5/19	0.00	7.69		Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	CPL
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
110	QC 9	1 pcs	2/5/19	0.00	0.00		Large Fab - 9	
							QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	MS
							QC 9 - 50	
120	QC 5	1 pcs	2/5/19	0.00	0.00		QC 9 - 9	
							QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	MS
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	

Entered: _____ Date: _____

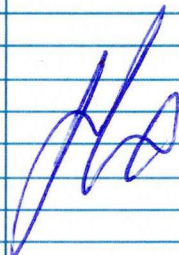


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130 Powdercoat - 4 Black Sand -B4B 1 pcs	2/5/19	0.00 0.42	Powdercoat - 1 - B4B	BFB19-01-18	
			Powdercoat - 2 - B4B		
			Powdercoat - 3 - B4B		
			Powdercoat - 4 - B4B		
140 Handfinish - 3-1- WingWalk-B4B 1 pcs	2/5/19	0.00 0.88	Handfinish - 3 - 1 - B4B	* 19-01-23	
			Handfinish - 3 - 2 - B4B		
			Handfinish - 3 - 3 - B4B		
			Handfinish - 3 - 4 - B4B		
			Handfinish - 3 - 5 - B4B		
150 QC 3 1 pcs	2/5/19	0.00 0.00	QC 3 - 10		
			QC 3 - 13		
			QC 3 - 15		
			QC 3 - 17		
			QC 3 - 18		
			QC 3 - 2		
			QC 3 - 26		
			QC 3 - 28		
			QC 3 - 3		
			QC 3 - 30		
			QC 3 - 34		
			QC 3 - 36		
			QC 3 - 38		
			QC 3 - 41		
			QC 3 - 51		
			QC 3 - 58		
			QC 3 - 59		
			QC 3 - 6		
			QC 3 - 68		
			QC 3 - 9		
160 Packaging 3-1 - Stock - B4B 1 pcs	2/5/19	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		

Entered: _____ Date: _____



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Other/Details:					

170 QC 21 - SA

1 pcs

2/5/19

0.00 0.00

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

QC 21 - SA - 21

QC 21 - SA - 70

DAG

21

3-15

JAN 23 7:19

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____) 1- assemble ribs , weld as per dwg D4018 using DT9607B 2- weld
 Descriptions: hinge (3) and Mounting brackets as per dwg D4018 ***inspect before welding mesh*** 3- Cut mesh as per dwg D4020-7
 4- tack weld mesh on basket as per dwg D4018 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) *** mask sides of hinge prior to powdercoat***

140 - (Wing Walk as per dwg QSI005 4.4 Batch 41384) - Mask data plate and apply wing walk on outside surface of
 mesh as per dwg Install placard and label as per dwg

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

M18839 START: 9:00 TEMP: 320° FINISH: 9:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>510588 5143339</u>
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	<u>5110937</u>
D4018-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5111234</u>
D4018-3	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5111293</u>
D4018-5	Rib	6 pcs (6 ea)	100-Large Fab - Basket - 1	<u>5124802 5143384</u>
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	<u>5114289</u>
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	<u>5143614 5140450</u>
M304EX0.75-16F	Expanded Metal Flat SS	16 sf (16 ea)	100-Large Fab - Basket - 1	<u>5109214</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	15	0
	D4016-3	3	185	0
	D4018-1	2	14	0
	D4018-3	2	14	0
	D4018-5	6	18	0
	D4021-3	1	12	0
	D4035-043	2	4	0
	M304EX0.75-16F	16	1,500	0

Part Specifications

Specifications could not be found.

Plex 1/4/19 12:08 PM Dart.lajeunesse.marie

007462



Container No: S144498



Part: D4018-041

Job No: 188226

Serial No/Batch: S144498

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 01/14/19

Entered: _____ Date: _____



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